



Dart Aerospace Ltd.
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D3531-3
Job Sheet 203158



Part No: D3531-3

Job Qty: 4 pcs

Part Name: Bracket Front Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 4,5 IPP Rev:A New Issue 07-09-24 EC verified by DD IPP REV:B 12.10.24 PER DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		11/25/19	0.17	0.26	Waterjet - Flow		JRB 11/29/19
120	QC 8	4 pcs		11/25/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
140	Small Fab - Brake NC - B4B	4 pcs		11/25/19	0.25	0.38	Small Fab - Brake - 1 - B4B		DAS 20 DEC 04 2019

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Container No: S235938

Part: D3531-3

Job No: 203158

Serial No/Batch: S235938

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19

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150	QC 5	4 pcs	11/25/19	0.00 0.00	Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Handfinish - 1-1 Chemical-B4B	4 pcs	11/25/19	0.00 0.21	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	QC 7	4 pcs	11/25/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	

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9-89

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				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	DEC 05 2019 DAS 40
				QC 7 - 24	9-89
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
180	Packaging 3-1 - Stock - B4B	4	11/25/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B QA/29
					Packaging 3 - 5 - B4B DAS 74
					Packaging 3 - 6 - B4B 9-89
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
190	QC 21 - SA	4	11/25/19	0.00 0.00	QC 21 - SA - 21 DAS
	pcs				QC 21 - SA - 70 21
					QC 21 - SA - 53 9-89

Part Op 100 - 1-Cut as per Dwg D3531 Dwg Rev: **B** Prog Rev: **B** 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)

- 140 - (Bend/Assemble as per dwg)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.5252 sf (.1313 ea)	100-Waterjet - Flow - 1	SK0195

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	1	195	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket Front Plate	0.129Inches + 0.005 - 0.001	0.134 0.128		Diameter
2	Bracket Front Plate	3.720Inches ± 0.030	3.750 3.690		
3	Bracket Front Plate	0.370Inches ± 0.030	0.400 0.340		
4	Bracket Front Plate	2.840Inches ± 0.010	2.850 2.830		
5	Bracket Front Plate	0.880Inches ± 0.030	0.910 0.850		
6	Bracket Front Plate	3.500Inches ± 0.030	3.530 3.470		
7	Bracket Front Plate	4.670Inches ± 0.030	4.700 4.640		

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DART AEROSPACE LTD		Work Order: 203158
Description: Bracket Front Plate		Part Number: D3531-3
Inspection Dwg: D3531	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130			Vernier	
3.72	+/-0.030	3.722			Tape	
0.37	+/-0.030	0.374				
2.840	+/-0.010	2.844				
0.88	+/-0.030	0.888				
3.50	+/-0.030	3.50				
4.67	+/-0.030	4.671				

Measured by: JRB	Audited by: DAS 40 9-89	Preliminary Approval:
Date: 11/29/19	Date: NOV 29 2019	Date:

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	
B	13.07.18	Dwg Rev updated	KJ	AA

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					